

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008287**Date Inspected:** 22-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Zhong An		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG outside segments-

This QA observed a weld excavation exceeding 65% on OBG segment 6W, weld FB035-001-184 SPCM material on 7/21/09 at approximately 2215 hours. ZPMC Quality Control (QC) was not available to verify repair documentation. Caltrans QA requested the CWR from ZPMC QC at 1900 on the 7/22/09. ZPMC QC stated that they would issue a CWR for engineering approval for this repair. The Weld repair had been completed by ZPMC without engineering approval. An incident report has been issued for the above mentioned repair.

OBG Trial Assembly Yard-

Caltrans QA performed MT verification of OBG Segment 4AE excavation area after air carbon arc gouging of Deck Panel Diaphragm to Floor Beam fillet welds in preparation for a Complete Penetration Joint weld SSD020-PP025-004.

Bay 10-

This QA Inspector observed the following work in progress: FCAW welding of weld SSTL3-1 B/K-81 B/K on South Tower Lift 3. ZPMC welders were identified as 040338 and 050041. ZPMC QC is identified as Liu Zhong

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2231-C-U2-F.

Bay 11-

This QA Inspector observed the following work in progress: SAW welding of West Tower skin plate D corner weld seam located on South Tower Lift 3. ZPMC welders were identified as 052917, 209105 and 050295. ZPMC QC is identified as Liu Zhong An. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-C-U2b-S-2.

Bay 11-

This QA Inspector observed the following work in progress: FCAW welding of Doubler Plate weld joint, ESD1-FASA4-2 A/E-32 located on East Tower Skin Plate A Lift 4. ZPMC welder was identified as 068858. ZPMC QC is identified as Li Hong Fei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2332-TC-P4-F.

SAW welding of weld joint, WSD1-FCSA4-4 A/D-6A and 7A located on Lift 4 West Tower Skin Plate D. ZPMC welder was identified as 202756. ZPMC QC is identified as Yu Dong Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2221-B-U3C-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversations between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
